

(19)



Europäisches Patentamt

European Patent Office

Office européen des brevets



(11)

EP 0 842 722 B1

(12)

EUROPEAN PATENT SPECIFICATION

(45) Date of publication and mention
of the grant of the patent:
16.08.2000 Bulletin 2000/33

(51) Int Cl.7: **B23B 27/10**

(21) Application number: **97119435.2**

(22) Date of filing: **06.11.1997**

(54) **Cutting insert with internal cooling for chip removing machining**

Schneideinsatz mit interner Kühlung für eine spanabhebende Bearbeitung

Plaquette de coupe à refroidissement interne pour usinage

(84) Designated Contracting States:
DE FR GB IT SE

(30) Priority: **18.11.1996 SE 9604203**

(43) Date of publication of application:
20.05.1998 Bulletin 1998/21

(73) Proprietor: **SANDVIK AKTIEBOLAG**
811 81 Sandviken (SE)

(72) Inventor: **Lagerberg, Stig**
811 52 Sandviken (SV)

(74) Representative: **Taquist, Lennart et al**
Sandvik AB
Patent Department
811 81 SANDVIKEN (SE)

(56) References cited:

DE-C- 750 860 US-A- 3 971 114

- **PATENT ABSTRACTS OF JAPAN vol. 095, no. 006, 31 July 1995 & JP 07 062982 A (OKUMURA CORP), 7 March 1995,**
- **PATENT ABSTRACTS OF JAPAN vol. 010, no. 218 (M-503), 30 July 1986 & JP 61 056807 A (INOUE JAPAX RES INC), 22 March 1986,**
- **DATABASE WPI Section PQ, Week 8612 5 April 1986 Derwent Publications Ltd., London, GB; Class P54, AN 86-080123 XP002057300 & SU 1 175 611 A (MIKHAILOV M I) , 30 August 1985**

Note: Within nine months from the publication of the mention of the grant of the European patent, any person may give notice to the European Patent Office of opposition to the European patent granted. Notice of opposition shall be filed in a written reasoned statement. It shall not be deemed to have been filed until the opposition fee has been paid. (Art. 99(1) European Patent Convention).

EP 0 842 722 B1

Description

The technical area of the invention

[0001] This invention refers to a cutting insert according to the preamble of claim 1 with internal cooling intended for chip removing machining, which is limited by an upper side, an underside and one or more side faces which extend between these, and which includes, on the one hand at least one cutting edge in the area of the said upper side and in addition a clearance surface connected to the cutting edge which at least partially forms a side surface, and on the other hand means by which a cooling medium can be guided in a direction towards the cutting edge in order to cool the said edge.

Background and prior art of the invention

[0002] Cutting inserts for chip removing machining become heated under the machining operations, whereafter the heat quickly spreads through the cutting insert. The cutting insert - which generally consists of cemented carbide - therefore reaches, in a very short time, a range of temperatures within which the resistance to plastic deformation of the cutting insert material decreases. When large cutting forces act on the cutting insert this phenomenon entails a risk that the cutting insert will be subject to plastic deformation in particular in the proximity of the cutting edge, whereby insert breakage can result. In order to diminish the risk of plastic deformation an efficient system for the cooling of the the cutting insert is required such that the working temperature of the insert can be regulated within desired limits. Generally the cutting insert and the surrounding, so called cutting zone, is cooled by a cooling medium in fluid form which is led from outside to flow towards the area where the heat is generated. Previously such a supply of cooling medium has been generally arranged from above and been directed towards the cutting insert and the chips which are broken against the chip breaking upper side of the cutting insert. This method of supply however results in only a very limited amount of the cooling medium having any practical effect on the cutting insert, because of the presence of the chips the cutting edge is only exposed to the cooling medium to a very limited degree

[0003] Another means of supplying cooling medium in fluid form is to steer the said medium in a direction between the chip breaking surface of the cutting insert and the chip itself. However, when the cooling liquid is applied at normal pressures this procedure does not result in any significant improvement in cooling effect compared to the aforementioned method, this is because the cooling liquid does not reach that part of the cutting insert which is hottest and which is exposed to the greatest mechanical load. Thus the clear risk that the cutting insert becomes plastic because of excessively high temperature. The effect of the cooling can certainly be in-

creased considerably by increasing the pressure of the cooling liquid to very high levels, e.g. 250-300 Mpa, but the equipment required to raise the cooling liquid pressure to this level is very complicated and expensive. Working with extremely high fluid pressure is furthermore, in practice, associated with appreciable safety risks.

[0004] In order to overcome the problem indicated above it has been proposed more recently that the cutting insert itself be cooled from within with the prime aim of holding the temperature in the cutting insert at such a low level that the risk of plastic deformation is to all intents and purposes eliminated. Several different solutions as to the problem of how to provide internal cooling of cutting inserts are to be found in the patent literature for this area. Thus SE 467 649 describes a cutting insert which is composed of two identical, partial bodies which are sintered together in such a way as to form internal, open channels through which the cooling medium can flow. SE 429 934 describes a cutting insert with a transverse hole through which cooling medium can pass from an underlying shim in the direction towards a separate cover plate on the upper side of the cutting insert in order to be finally directed towards the cutting edge of the insert. FR 2 244 590 describes a cutting insert with a transverse channel for the cooling medium which stretches from the under side of the cutting insert to the upper side where it discharges in the immediate vicinity of the cutting insert's cutting edge. EP 0 534 450 describes a cutting insert for parting with an open groove in the clearance surface of the cutting insert for the transport of cooling medium from a channel in the corresponding tool holder in the direction of the cutting insert edge. US 5 237 894 describes a cutting insert with a transverse, open channel for cooling liquid which terminates in an opening on the upper side of the cutting insert.

[0005] Common to all the solutions to the problem indicated above, which are based on transverse or open channels respectively grooves for feeding the cooling medium, is that the channels weaken the cutting insert in the cutting edge area and that there is a risk that the channels will be blocked by the hot material of the chip which sticks to the insert surface. Furthermore the existence of the channels, respectively the grooves limits the possibilities to design the cutting insert with an optimal chip breaker geometry. It should also be mentioned that SE 377 290 describes a cutting insert with an internal cavity in which cooling medium can circulate. However this cavity weakens the cutting insert to such a large degree that it cannot be used practically when exposed to typical cutting forces.

[0006] Document US-A-3 971 114 discloses a cutting insert according to the preamble of claim 1.

Purposes and features of the invention

[0007] The aim of the present invention is to eliminate the drawbacks of inserts with an internal coolant supply

for chip removing machining as mentioned above and create an improved cutting insert. One basic purpose with the invention is thus to create a cutting insert which can be cooled efficiently without the assistance of open channels or grooves which run the risk of being clogged by chips. Another aim is to create a cutting insert which can be cooled efficiently by an internal supply of cooling medium without the mechanical strength of the cutting insert being significantly reduced and without the external geometry of the cutting insert, e.g. the chip breaking geometry, being limited because of the means necessary for the supply of cooling medium. A further purpose is to create a cutting insert which allows an efficient steering of the flow of cooling medium to the immediate vicinity of the edge without weakening or deteriorating the surface which is exposed to direct mechanical load from the chips in comparison to conventional, externally cooled cutting inserts. A further purpose is to create a cutting insert which, despite efficient cooling of the cutting edge of the cutting insert, does not require anything more than limited amounts of cooling medium. According to the invention at least the basic object is achieved by means of the features indicated in claim 1 characteristics part. The preferred design of the cutting insert according to the invention is indicated in more detail in the dependent claims.

Short description of enclosed drawings

[0008] The drawings show:

- Fig 1 a schematic, perspective, exploded view showing a completed cutting insert according to the invention produced in an embodiment in which the cutting insert is mounted in a tool holder with the help of a screw,
- Fig 2 an enlarged section through the cutting insert only, according to fig 1,
- Fig 3 a section showing the cutting insert as assembled in the holder, wherein only a forward part of the cutting insert holder is shown and wherein the clamping screw is shown partly in view, partly in section,
- Fig 4 a perspective, exploded view showing a cutting insert according to the invention which can be assembled with the help of a so called clamp, whereby a shim is placed under the cutting insert,
- Fig 5 an enlarged section through the forward part of the insert holder according to fig 4, whereby both the cutting insert and the shim are held locked in position with the aid of the clamp,
- Fig 6 a section showing an alternative embodiment of the cutting insert and shim,
- Fig 7 a view of the the cutting insert and shim according to fig 6 in an exploded view.

Detailed description of the preferred embodiment of the invention

[0009] In fig 1 a cutting insert in general according to the invention is designated as 1 and it can be assembled in a holder designated as a unit with 2. In the example shown this is achieved with the help of a clamping screw 3. The cutting insert holder 2, of which only a forward part is illustrated in fig 1, has the form of a shank which has cylindrical basic form with the exception of a plane surface. At the forward end of the shank an insert seat 4 is cut out and it is bordered by a bottom surface 4' and two side faces 4'' positioned at an angle. The cutting insert 1 shows a central, transverse hole 10 for the clamping screw 3, which is provided to be screwed down into a threaded hole 5 which terminates in a hole in the bottom surface 4'.

[0010] Generally the cutting insert 1 is limited by an upper side 6, an underside 7 (see fig 2) as well as a number of, more exactly four, side faces 8 which extend between the upper and the under sides. In the embodiment taken as an example the cutting insert is thought to have a positive geometry, wherein at least one edge 9 is formed between the upper side 6 and an inclined side surface 8 which forms a clearance surface.

[0011] Now referring to fig 2 and 3 which clarify what is new and characteristic for the cutting insert 1 according to this invention. Characteristic is thus that the cutting insert includes at least one supporting body 11 with a porous material structure through which pores a cooling medium can flow, and that this supporting body 11 is at least partially surrounded by a thin surface layer 12 with an impermeable, non-porous material structure through which the same cooling medium cannot pass or can only pass with great difficulty. In the example shown the cutting insert includes a single coherent, porous supporting body 11, which occupies a larger part of the total volume of the cutting insert. A wear body 13 is also included in the cutting insert and it, like the surface layer 12 has a compact, non-porous material structure. The wear body 13 is however considerably thicker than the surface layer 12. Thus, in practice, the outer layer 12 can have a thickness of only some few or some ten or so microns, while the wear body 13, which is connected to the upper side of the cutting insert, can have a thickness in the range of 0,5-1,5 mm, suitably about 1 mm (under the assumption that the cutting insert has a total thickness of a magnitude of 3-7 mm). Fig 2 clearly shows how the aforementioned cutting edge 9 is formed on the wear body 13 which is relatively thick when compared to the surface layer 12. In the example shown the substantially plane wear body 13 extends along the entire upper side of the cutting insert in order to completely cover it. It is however also conceivable to develop a thick wear body only connected directly to the cutting edge 9, while remaining parts of the upper side of the cutting insert are covered by a thinner surface layer.

[0012] The actual supporting body 11 can, in principle,

be produced by sintering the same kinds of powder materials which are used for the production of conventional cemented carbide- or cemented carbide inserts with a compact material structure, such as metal carbides, metal nitrides, ceramics or such like. More exactly, powder materials with comparatively large grain sizes are selected, e.g. in the range of 20-100 μm , and combined with a filler which is burnt off and/or gasified in connection with sintering. After the customary compacting process of a mixture of powder and filler (possibly together with a particular binder material) during the formation of an insert body with a nominal shape, the body is sintered at high temperature, e.g. of the magnitude of 1200 °C. Whereby the individual powder grains are sintered together via atomic, point or sporadic bindings on the surfaces of the grains and at the same time the filler in the microscopic spaces between the powder grains is burnt up and gasified. In this manner the finished supporting body is formed with a micro-porous material structure through which at least gaseous cooling media can flow without the need to be subjected to other than moderate pressure.

[0013] In contrast to the manner in which the micro-porous supporting body 11 is produced not only the thin surface layer 12, but also the thicker wear body 13 on the upper side of the cutting insert are provided with a powder mixture which gives an impermeable, non-porous material structure. In this manner in particular the wear body 13, but also the surfacer layer 12, can have the same compact material structure as conventional cemented carbides or hard materials. In order to integrate the compact components of the cutting insert, i.e. the thick and mechanically much stronger wear body 13 as well as the thinner surface layer 12, with the micro-porous supporting body 11 two principal alternative methods of manufacturing are available. One conceivable approach is to introduce, in some suitable manner, the powder mixtures which will form components 12, 13 in the same die as the powder mixture which will form the support body 11 and press them together prior to the final sintering. The second alternative is to press and sinter at least the porous supporting body 11 in a separate operation and subsequently sinter together the supporting body with the material or materials which will form the impermeable components 12, 13.

[0014] Another characteristic feature of the invention is that there are to be at least two openings in the impermeable shell (composed of the surface layer 12 and the wear body 13) which encloses the porous support body 11 the said openings to expose the porous structure of the support body. Thus a first opening 14 is to be found in the outer layer 12 which serves as an entrance for the supply of a cooling medium to the inner of the supporting body. Another opening 15 serves as an outlet for the cooling medium from the inner of the supporting body. This opening for the outflow 15 is placed as near the cutting edge 9 as possible. In the case in question the opening 15 is placed immediately under the forward

part of the wear body 13 on which the cutting edge 9 is formed (in the example illustrated the cutting insert is thought of as being reversible and having at least one additional edge 9', whereby an opening for the outflow 15' is even to be found in the proximity of this edge).

[0015] In the embodiment shown in fig 2 and 3, in which the cutting insert is fixed in the cutting insert holder with the help of a screw and therefore has a central hole 10, the entrance for the inflow 14 for the cooling medium is formed as a circular groove in that part of the surface layer 12, which in addition covers the rotationally symmetrical wall which delimits the hole. At the same time the underside of the cutting insert is completely covered by the outer layer 12. The surface layer 12 extends along the side faces of the cutting insert up to the wear body 13, with the exception of the relatively small hole or holes 15 which form the outlet for the cooling medium. As is clearly shown in fig 2 and 3, the opening for the outflow 15 has a height which is less than half the thickness of the cutting insert, wherein the opening is placed in direct connection to the under side of the wear body 13.

[0016] During the practical production of the cutting inserts according to this invention it should be necessary in the first stage to completely encase the micro-porous supporting body in an encapsulating, impermeable shell (consisting either of only a thin surface layer or, as is shown in fig 2 and 3, of a combination of a thin surface layer and a thicker wear body) and subsequently by some suitable means to open up the above mentioned entrances and exits for the in- and outflow with the help of some appropriate machining operation. Examples of such machining can be etching, blasting, grinding or spark erosion.

[0017] It is most advantageous to use a gaseous medium e.g. a cryogenic gas, such as nitrogen (N_2) which is subjected to a heightened, although moderate pressure (e.g. in the range of 20-25 bar) as cooling medium for a cutting insert according to the invention.

[0018] The supply of the cooling medium to the actual cutting insert is arranged for the preferred design as shown in fig 1-3, with the help of the threaded hole 5 and the screw 3. More exactly a recessed channel 16 is provided in the cutting insert holder 2 the one end of which can terminate in a rear, not shown, part of the cutting insert holder, whilst the other end terminates in the threaded hole 5. In fig 3 this end of the channel is designated 16'. In fig 3 it is clearly shown how this end of the channel terminates in the bottom of the threaded hole 5. In fig 1 it can be further seen that the clamping screw 3 features an axial groove 17, which extends along the threaded part of the screw to the head of the screw. This groove has a depth which is at least somewhat larger than the height of the threaded bore; something which means that the lower part of the groove forms a free channel or passage even when the male thread part of the screw is screwed down tightly into the hole's female thread. In other words the cooling medium

from the channel 16 is fed through the channel groove 17 in the screw to the ring-shaped space 18 which exists between the outer surface of the screw and the inside of the hole 10 as a result of the fact that the hole has a larger diameter than the threaded part of the screw. Up-
 5 wards, this ring-shaped space 18 is delimited by the head of the screw 3', it can be advantageous if this has a conical shape in order to effectively seal against an upper portion of the hole 10' which gets progressively wider in the upwards direction and which has a slightly
 10 arched form.

The cutting insert described functions in the following manner. When the cutting insert is clamped in the seat 4 of the holder 2 by screwing down the screw 3 into the threaded hole 5 the cooling medium can be fed forwards
 15 into channel 16 in the cutting insert holder. Via the channel groove 17 and ring shaped space 18 the cooling medium flows forwards to the ring-shaped entrance for the inflow 14 in the impermeable outer layer of the cutting insert, wherein the cooling medium is pressed into the
 20 micro-porous inner of the supporting body 11. The cooling medium is forced onwards via pores in this structure further towards the outflows 15, 15' in connection with the cutting edges 9, 9', due to the fact that the outer surface of the supporting body is covered by the shell which
 25 is formed jointly by the upper wear body 13 as well as the outer layer 12 on the under side and side faces of the body. Due to the fact that the opening for the outflow 15' which works together with the temporarily inactive cutting edge 9' is reversed and placed against the side
 30 surface 4" which delimits the cutting insert pocket 4, the flow of cooling material through the opening for the outflow is impeded or stopped. In other words more or less all the cooling medium will flow out from the cutting insert through the opening for the outflow 15 which is to be
 35 found in the immediate proximity of the active working cutting edge 9.

[0019] An alternative embodiment is shown in fig 4 and 5 in which the cutting insert 1' is held fixed on the cutting insert holder 2' with the help of a conventional
 40 clamp 19 instead of with a transverse screw. In the example shown a special shim 20 is provided between the cutting insert 1' and the bottom of the seat 4'. In this case the bottom of the seat lacks any threaded hole, which is why a channel 16 for the cooling medium discharges
 45 directly into the bottom of the seat.

[0020] As is shown fig 5 the cutting insert 1', includes in addition to a micro-porous supporting body 11 and an upper, relatively thick wear body 13, a surface layer 12 which only extends along the side faces of the cutting
 50 insert (with the exception of one or more the openings for the outflow where the outer layer is removed and the porous structure of the supporting body is uncovered). The surface layer on the under side of the cutting insert is however wholly or partly missing. This means that the porous structure of the supporting body is open and exposed in the downward direction, whereby the entire or
 55 part of the under side of the cutting insert forms an en-

trance 14 for the inflow of the cooling medium.

[0021] The shim 20 consists, in a similar manner to the cutting insert, of an insert body with a micro-porous material structure, whereof only the side faces of the shim are covered by a surface layer 12 of an impermeable, non-porous structure. In other words the porous structure of the body is exposed both upwards and downwards. The upper side of the shim thus forms an opening for the outflow of the cooling medium, whilst the underside forms an opening for the inflow. Via these en-
 10 trances the inflow of the cooling medium from channel 16 can be lead into the shim and further up through supporting body 11 of the cutting insert in order to finally flow out through the opening for the output 15 in ques-
 15 tion.

[0022] An additional alternatively embodiment is illustrated in fig 6 and 7 in which the cutting insert is clamped with the help of a screw at the same time as a shim is inserted between the cutting insert and the bottom of the seat. Analogous with the design shown in fig 4 and 5 the under side of the cutting insert is open, in addition to which the upper- and lower sides of the shim are open at the same time as the side faces of the shim and the cutting insert are covered with a sealing surface layer
 20 12 (the surface coating of the sides of the actual cutting insert feature, of course, at least one opening 15 for the outflow). Centre holes for the screw 3 are provided in both the cutting insert and the shim. Characteristic for the practical embodiment shown is that the rotationally symmetrical walls which delimit these holes are covered by surface layer 12 which impedes the cooling medium from being led into the ring-shaped space between the outside of the screw and the walls of the hole. In a similar way to the embodiment shown in fig 4-5 the cooling medium is led into the under side of the shim via a channel
 25 16. This channel is kept separate from the threaded hole 5 in the cutting insert holder which receives the screw 3.

The advantages of the invention

[0023] One advantage of the cutting insert according to the invention is that it enables efficient cooling of just that part of the cutting insert which is dependent on being cooled, namely the cutting edge part. This advantageous effect is attained by forceably guiding the cooling medium through an opening for the outflow situated in the immediate vicinity of the cutting edge. In the embodi-
 40 ments shown the opening for the outflow in the question is localised in the clearance surface of the cutting insert, whereby an additional advantage is won in that the cooling medium will also have an effect directly on the workpiece. The fact that the workpiece is also cooled in an efficient manner improves the dimensional accuracy of this since plastic deformation of the actual workpiece is avoided. A further advantage is that cooling occurs completely without the assistance of open channels or grooves. This means that the cutting insert can be designed with optimal geometry without the hindrance of

such channels. The existence of the particularly robust wear body in the upper surface of the insert which is composed of a compact material structure permits the insert to be exposed to considerable mechanical loads from the chips without damage occurring.

Additional elucidation of the prior art

[0024] The production of sintered metallic bodies with a micro-porous inner material structure is in itself known previously through SE 454 247 and EP 0 574 475. In these cases however the metallic bodies are utilized as dies for e.g. the casting of plastic components, whereby the role of the pores in the body of the die is to temporarily absorb those gases which are given off during pressing.

Conceivable modifications of the the invention

[0025] The invention is not limited only to the designs described and shown on the drawings. Instead of the square or quadrilateral shapes shown the cutting insert can have other arbitrary basic forms, e.g. triangular or other forms of polygonal shape as well as circular or rotationally symmetrical shapes (in the latter case the cutting insert includes only a single continuous side surface). Instead of the positive cutting geometry shown the cutting insert can also have neutral or negative insert geometries. Further the specially, thick wear body on the upper side of the cutting insert can be dispensed with, whereby the micro-porous upper surface of the supporting body is only covered by a comparatively thin, protective surface layer with an impermeable material structure.

Claims

1. A cutting insert which can be cooled internally for chip removing machining, which is limited by an upper side (6), an underside (7) and one or more side faces (8) which extend between these, and which comprise partly at least an edge (9) in the area of the said upper side and a clearance surface connected to the cutting edge which at least partially forms a side surface (8), and partly means by which cooling medium can be guided in the direction of the cutting edge (9) in order to cool said cutting edge, characterized in that it comprises at least a supporting body (11) with a porous material structure through the pores of which the cooling media can flow as a means by which to guide the cooling medium forwards, and in that the said supporting body (11) is at least partially enveloped by a surface shell (12, 13) with an impermeable, non-porous material structure, and that at least two openings (14, 15) are made in this surface shell to get access to the porous structure of the supporting body, namely

a first opening (14) localised at a distance from the cutting edge which serves as an entrance for the supply of the cooling medium to the inside of the supporting body, and a second opening for the outflow of cooling medium from the porous inner of the supporting body, said second opening (15) being situated near the cutting edge (9).

2. Cutting insert according to claim 1 characterized in, that the porous supporting body (11) occupies a major part of the cutting insert's (1) total volume.
3. The cutting insert according to claim 1 or 2, is characterized in, that the cutting edge (9) is formed of a compact, non-porous material manufactured wear body (13), which is thicker than a thin surface layer (12) and extends from said clearance surface (8) along at least a part of the upper side of the cutting insert.
4. Cutting insert according to claim 3 characterized in, that the wear body (13) extends along the entire upper side of the cutting insert (1) in order to completely cover it.
5. Cutting insert according to claim 3 or 4, characterized in, that said surface layer (12) extends along the entire side surface (8) of the cutting insert with the exception of at least one opening for the outflow (15) the height of which is less than half the thickness of the cutting insert and which is placed in immediate connection to the cutting edge (9) or the wear body (13) on which this is formed.
6. Cutting insert according to anyone of the preceding claims, characterized in, that the entrance for the inflow (14) for the cooling medium to the inside of the supporting body (11) discharges in the lower side of the cutting insert.
7. Cutting insert according to claim 6 characterized in, that the lower side of the cutting insert is substantially wholly open, ie lacks the impermeable skin along substantially the entire length of its surface in order to provide maximum supply of cooling medium from the upper side of an underlying shim (20) which in a similar manner to the supporting body of the cutting insert has a porous material structure and which therefore allows passage of cooling medium via pores therein.
8. Cutting insert according to anyone of the claims 1-5, including a transverse hole (10) for a clamping screw (3), characterized in, that the opening (14) in the surface shell (12) which serves as an entrance for the cooling medium is localised close to the hole (10) to provide transport of the cooling medium from the actual hole to the porous inside of the supporting

body (11).

9. Cutting insert according to anyone of the claims 1-5, including a transverse hole for a clamping screw, characterized in, that the impermeable surface shell (12) covers the wall which delimits the hole (10) and that the entrance for the inflow (14) for the cooling medium terminates in the lower side of the cutting insert or in a side surface at a distance from the cutting edge.

Patentansprüche

1. Schneideinsatz, der im Inneren gekühlt werden kann, für spanabhebende Bearbeitung, welcher durch eine Oberseiten (6)-, eine Unterseiten (7)- und eine oder mehrere Seitenflächen (8), die sich zwischen diesen erstrecken, begrenzt ist und der teils wenigstens eine Kante (9) in der Fläche der Oberseite und eine Freifläche, die mit der Schneidkante verbunden ist, welche wenigstens teilweise eine Seitenfläche (8) bildet, und teils eine Einrichtung, durch welche Kühlmedium in der Richtung der Schneidkante (9) geführt werden kann, um diese Schneidkante zu kühlen, umfaßt, **dadurch gekennzeichnet**, daß er wenigstens einen Stützkörper (11) mit einer porösen Werkstoffstruktur, durch deren Poren das Kühlmedium fließen kann, als ein Mittel umfaßt, durch welches das Kühlmedium nach vom geführt wird, und daß dieser Stützkörper (11) wenigstens teilweise von einem Oberflächenmantel (12, 13) mit einer undurchlässigen, nichtporösen Werkstoffstruktur umhüllt ist und daß wenigstens zwei Öffnungen (14, 15) in diesem Oberflächenmantel ausgebildet sind, um Zugang zu der porösen Struktur des Stützkörpers zu bekommen, nämlich eine erste Öffnung (14), die in einem Abstand von der Schneidkante angeordnet ist und als ein Eingang für die Zufuhr des Kühlmediums zu der Innenseite des Stützkörpers dient, und eine zweite Öffnung für den Ausfluß von Kühlmedium aus dem porösen Inneren des Stützkörpers, wobei diese zweite Öffnung (15) nahe der Schneidkante (9) angeordnet ist.
2. Schneideinsatz nach Anspruch 1, **dadurch gekennzeichnet**, daß der poröse Stützkörper (11) einen Hauptteil des Gesamtvolumens des Schneideinsatzes (1) einnimmt.
3. Schneideinsatz nach Anspruch 1 oder 2, **dadurch gekennzeichnet**, daß die Schneidkante (9) von einem kompakten, nicht aus porösem Material hergestellten Verschleißkörper (13) gebildet wird, welcher dicker als die dünne Oberflächenschicht (12) ist und sich von der Freifläche (8) entlang wenigstens einem Teil der Oberseite des Schneideinsatz-

zes erstreckt.

4. Schneideinsatz nach Anspruch 3, **dadurch gekennzeichnet**, daß sich der Verschleißkörper (13) entlang der gesamten oberen Seite des Schneideinsatzes (1) erstreckt, um ihn vollständig zu bedecken.
5. Schneideinsatz nach Anspruch 3 oder 4, **dadurch gekennzeichnet**, daß sich die Oberflächenschicht (12) entlang der gesamten Seitenfläche (8) des Schneideinsatzes mit Ausnahme wenigstens einer Öffnung für den Ausfluß (15) erstreckt, deren Höhe geringer als die halbe Dicke des Schneideinsatzes ist und die in unmittelbarer Verbindung mit der Schneidkante (9) oder dem Verschleißkörper (13), auf welchem sie ausgebildet ist, angeordnet ist.
6. Schneideinsatz nach einem der vorausgehenden Ansprüche, **dadurch gekennzeichnet**, daß der Eingang für das Einströmen (14) für das Kühlmedium zum Inneren des Stützkörpers (11) in die Unterseite des Schneideinsatzes mündet.
7. Schneideinsatz nach Anspruch 6, **dadurch gekennzeichnet**, daß die Unterseite des Schneideinsatzes im wesentlichen vollständig offen ist, d. h. die undurchlässige Haut entlang im wesentlichen der gesamten Länge seiner Oberfläche fehlt, um eine maximale Zufuhr von Kühlmedium von der Oberseite eines darunterliegenden Abstandsstückes (20) zu bekommen, welches in ähnlicher Weise wie der Stützkörper des Schneideinsatzes eine poröse Werkstoffstruktur hat und welches daher einen Durchgang von Kühlmedium durch Poren darin gestattet.
8. Schneideinsatz nach einem der Ansprüche 1 bis 5 mit einem Querloch (10) für eine Klemmschraube (3), **dadurch gekennzeichnet**, daß die Öffnung (14) in dem Oberflächenmantel (12), welche als ein Eingang für das Kühlmedium dient, nahe dem Loch (10) angeordnet ist, um das Kühlmedium von dem tatsächlichen Loch zu dem porösen Inneren des Stützkörpers (11) zu transportieren.
9. Schneideinsatz nach einem der Ansprüche 1 bis 5 mit einem Querloch für eine Klemmschraube, **dadurch gekennzeichnet**, daß der undurchlässige Oberflächenmantel (12) die Wand bedeckt, welche das Loch (10) begrenzt, und daß der Eingang für das Einströmen (14) für das Kühlmedium in der unteren Seite des Schneideinsatzes oder in einer Seitenfläche in einem Abstand von der Seitenkante endet.

Revendications

1. Plaquette de coupe qui peut être refroidie de façon interne destinée à un usinage avec un enlèvement de copeaux, qui est limitée par une face supérieure (6), une face inférieure (7) et une ou plusieurs faces latérales (8) qui s'étendent entre celles-ci, et qui comprennent en partie au moins une arête (9) dans la zone de ladite face supérieure et une surface de dépouille reliée à l'arête tranchante qui, au moins partiellement, forme une surface latérale (8), et en partie un moyen par lequel un agent de refroidissement peut être guidé en direction de l'arête tranchante (9) afin de refroidir ladite arête tranchante, caractérisée en ce qu'elle comprend au moins un corps de support (11) de structure en matériau poreux, au travers des pores duquel, les agents de refroidissement peuvent circuler, en tant que moyen grâce auquel l'agent de refroidissement est guidé vers l'avant, et en ce que le corps de support (11) est au moins partiellement enveloppé par un enrobage de surface (12, 13) par une structure en matériau non poreux imperméable, et en ce qu'au moins deux ouvertures (14, 15) sont réalisées dans cet enrobage de surface afin d'obtenir un accès à la structure poreuse du corps de support, à savoir une première ouverture (14) située à une certaine distance par rapport à l'arête tranchante qui sert d'entrée pour l'alimentation de l'agent de refroidissement vers l'intérieur du corps de support, et une seconde ouverture destinée à l'évacuation de l'agent de refroidissement depuis l'intérieur poreux du corps de support, ladite seconde ouverture (15) étant située à proximité de l'arête tranchante (9). 5
2. Plaquette de coupe selon la revendication 1 caractérisée en ce que, le corps de support poreux (11) occupe une majeure partie du volume total de la plaquette de coupe (1). 10
3. Plaquette de coupe selon la revendication 1 ou 2, caractérisée en ce que l'arête tranchante (9) est formée d'un corps d'usure fabriqué à partir d'un matériau non poreux compact (13), qui est plus épais qu'une couche de surface fine (12) et s'étend depuis ladite surface de dépouille (8) tout le long d'au moins une partie de la face supérieure de la plaquette de coupe. 15
4. Plaquette de coupe selon la revendication 3 caractérisée en ce que le corps d'usure (13) s'étend le long de la face supérieure de la plaquette de coupe (1) afin de la recouvrir complètement. 20
5. Plaquette de coupe selon la revendication 3 ou 4, caractérisée en ce que ladite couche de surface (12) s'étend le long de la surface latérale (8) de la plaquette de coupe à l'exception d'au moins une 25
- ouverture pour l'évacuation (15), dont la hauteur est inférieure à la moitié de l'épaisseur de la plaquette de coupe et qui est placée en liaison immédiate avec l'arête tranchante (9) ou le corps d'usure (13) sur lequel elle est formée. 30
6. Plaquette de coupe selon l'une quelconque des revendications précédentes, caractérisée en ce que, l'écoulement d'entrée (14) de l'agent de refroidissement vers l'intérieur du corps de support (11) débouche dans la face inférieure de la plaquette de coupe. 35
7. Plaquette de coupe selon la revendication 6 caractérisée en ce que, la face inférieure de la plaquette de coupe est pratiquement complètement ouverte, c'est-à-dire ne comporte pas de croûte imperméable sur pratiquement tout le long de sa surface afin de permettre une alimentation maximum en agent de refroidissement depuis la face supérieure d'une cale disposée en dessous (20) qui, de manière similaire au corps de support de la plaquette de coupe, présente une structure en matériau poreux et qui de ce fait, permet le passage de l'agent de refroidissement par l'intermédiaire des pores de celle-ci. 40
8. Plaquette de coupe selon l'une quelconque des revendications 1 à 5, comprenant un trou transversal (10) destiné à une vis de fixation (3), caractérisée en ce que l'ouverture (14) de l'enrobage de surface (12) qui sert d'entrée pour l'agent de refroidissement est situé à proximité du trou (10) afin de permettre le transport de l'agent de refroidissement depuis le trou lui-même vers l'intérieur poreux du corps de support (11). 45
9. Plaquette de coupe selon l'une quelconque des revendications 1 à 5, comprenant un trou transversal destiné à une vis de fixation, caractérisée en ce que, l'enrobage de surface imperméable (12) recouvre la paroi qui délimite le trou (10) et en ce que l'entrée destinée à l'écoulement d'entrée (14) de l'agent de refroidissement aboutit à la face inférieure de la plaquette de coupe ou à une surface latérale à une certaine distance depuis l'arête tranchante. 50

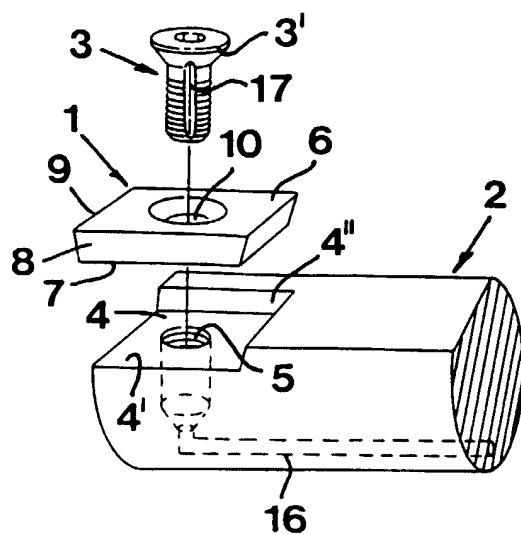


Fig 1

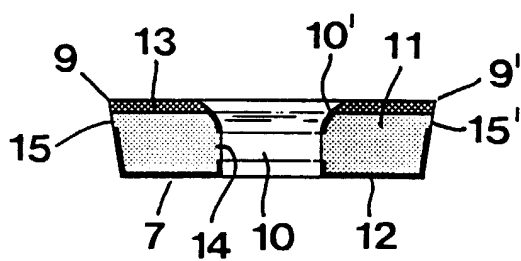


Fig 2

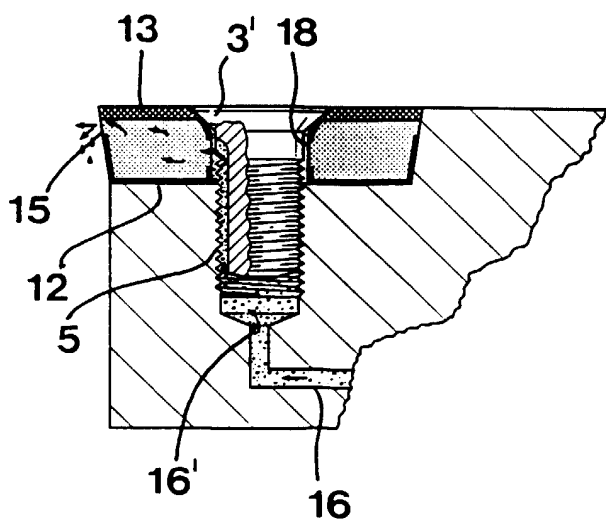


Fig 3

Fig 4

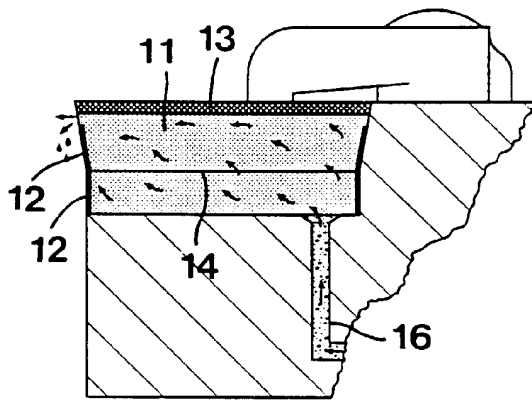
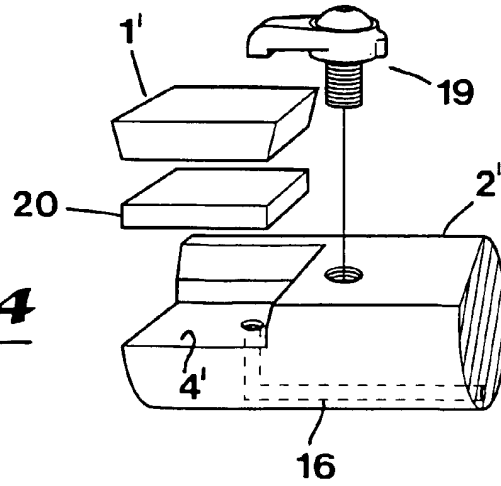


Fig 5

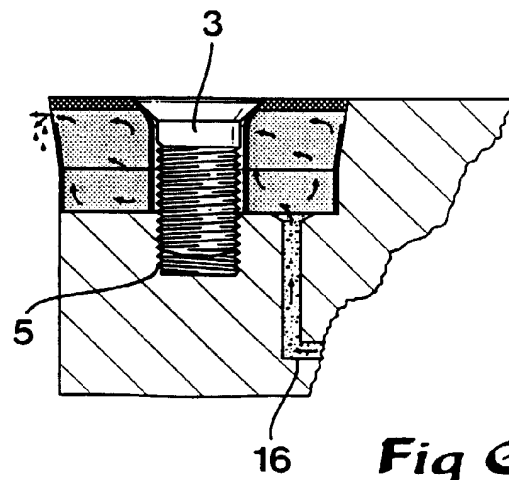


Fig 6

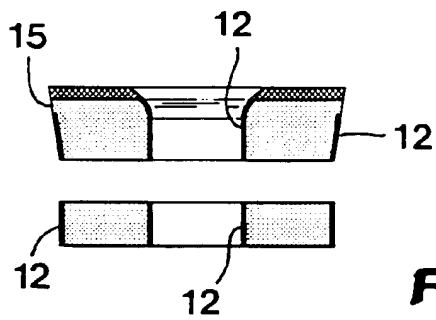


Fig 7